

5

543

DART AEROSPACE LTD		Work Order:	24588
Description: Stem RING		Part Number:	D3407-5
Dwg: D3407 Rev. C		Qty:	26
Page 1 of 1			

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JA	05.10.18	126
2	MS	Turn as per Folio FA598 Rev: <u>A</u> & Dwg D3407 Rev: <u>C</u> Material: 17-4ph SS Round Bar Ø3.000 (M17-4-R3.000) Identify for D3407-5 Batch: <u>1118742</u>	JA	05.10.21	126
3	QC2	Inspect parts as they come off the machine	JA	05.10.24	6
4	QC8	Second check	JA	05.10.24	6
5	MC	Deburr, no sharp edges	JA	05.10.24	6
6	ST	Identify and Stock	CPH	05.10.24	6
7	AC	Cost / part: <u>17.28</u>	SUC	05.10.25	6
8	DC	Close W/O <u>17.28</u> Inspect Level 21	JA	05.10.25	6

Rev	Date	Change	Revised By	Approved
A	05.10.18	New issue	KJ/EC	EC

RELEASED
05.10.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

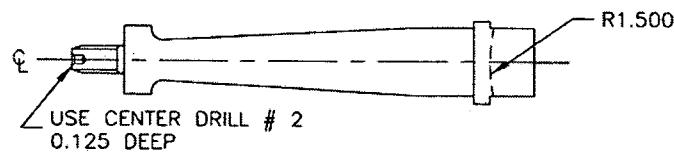
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *h* Date: 05/10/25

NOTE: Date & initial all entries

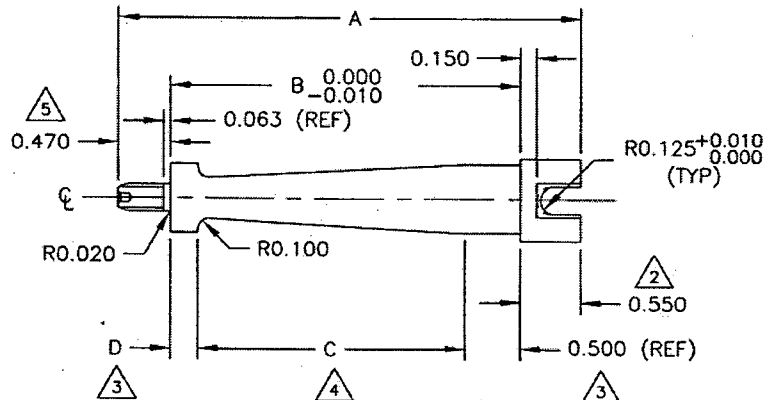
QA: N/C Closed: _____ Date: _____

05.10.21



RELEASED

05.09.12



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

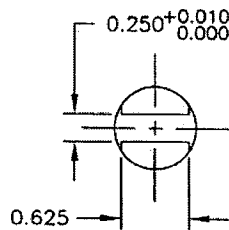
D3407-1/-3 STEM

D3407-1 AND D3407-3 STEM:

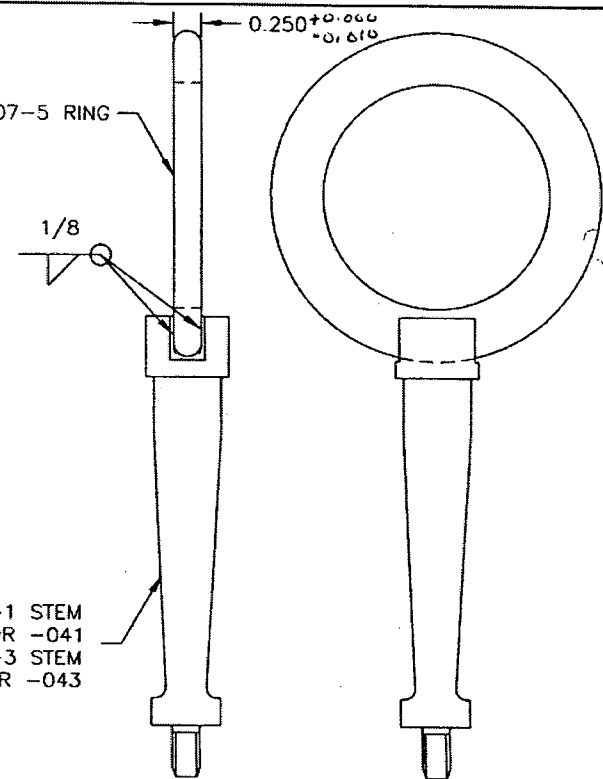
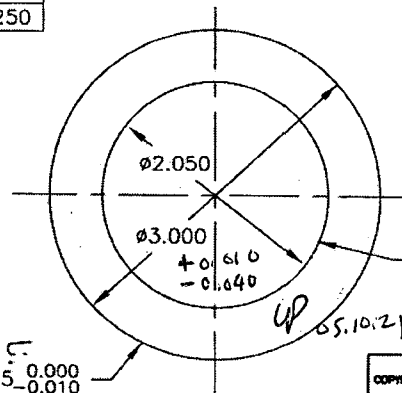
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2) $\phi 0.750$ O.D.
- 3) $\phi 0.625$ O.D.
- 4) MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D. TO $\phi 0.625$ O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3407-5 RING:

- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



USE D3407-1 STEM FOR -041
USE D3407-3 STEM FOR -043



D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING.
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEBURR 0.010 TO 0.020

C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	CP
CHECKED	CP	CP
DATE	05.09.09	TOW RING
DRAWING NO.	D3407	
TITLE	TOW RING	
REV.	0	
SHEET	1 OF 1	
SCALE	1:1	

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24588
ORDER
TO AMENDMENT
NOTICE
HOLLED COPY
ENGINEERING
RETURN TO
COPY

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 18, 2005
09:31 am

Work Order No : 0024588
Project Name : D3407-5
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D3407-5
Description : Ring
Manufactured : No
Amount Req'd : 0
Amount Done : 0
Start Date : 10-18-05
Est Finish Date : 10-21-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			




	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order:	24588
Description: Ring		Part Number:	DB407-5
Inspection Dwg: D3407-5 Rev: C			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☒ Prototype

[illegible]

Measured by: 	Audited by: 	Prototype Approval: 
Date: 05.10.24	Date: 05.10.24	Date: 05.10.24

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

Chris Provencal

From: David Shepherd [davids@dartaero.com]
Sent: October 21, 2005 12:35 PM
To: Chris Provencal
Subject: Re: D3407

I'm Ok with this. Drawing update to follow at a more convenient time.

David

----- Original Message -----

From: "Chris Provencal" <cprovencal@dartaero.com>
To: <davids@dartaero.com>
Sent: Friday, October 21, 2005 9:45 AM
Subject: D3407

>
> Dave, for the D3407 tow ring: For the OD for the ring, production wants
> 3.000+0.01/-0.04 to allow for variations in the purchased material. The
> current material is out of the dwg tolerance but would fall in the range
> of
> the tolerance above.
>
> You already given a verbal OK on this, but I will attach your email reply
> to
> the work order.
>
> I also tightened the tolerance on the thickness to 0.250+0/-0.01. If the
> thickness is over 1/4" then it'd be an interference fit with the shaft. I
> can do a hand change later to make these changes permanent.
>
>
> Sincerely,
> Chris Provencal
> DART Aerospace Ltd.
> Email..cprovencal@dartaero.com
> Phone...613-632-3336
> Fax.....613-632-4443
>
>